

# Work Order ID 62127

Thursday, September 16, 2010 10:59:29 AM



Page 1

Item ID: D3447-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Swing Arm

Start Date: 9/16/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *WLF*

Date: 10-9-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3447	Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.500" x 1.500" x 8.400" long

*SA 10/09/13*

*4* *SA*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA544 and Dwg B67-43001 Identify as D3447-9Dwg

Rev A Folio Rev A ☐ Debur

*B.A 10/09/26*

*4* *SA*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*B.A 10/09/26*

*4* *SA*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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**Work Order ID 62127**

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Item ID: D3447-9

Accept

Revision ID:

Item Name: Swing Arm

Start Date: 9/16/2010 Start Qty: 4.00

Required Date: 9/30/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

10/10/7-SP (40)

170

Identify as per dwg &amp; Stock Location: 442

0.00

Packaging

Memo

0.00

Packaging

10/10/7- 7 SP

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/10/08  
MF  
10-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 16, 2010 10:59:29 AM

Page 1

Work Order ID: 62127

Parent Item: D3447-9

Parent Item Name: Swing Arm



Start Date: 9/16/2010

Required Date: 9/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.08.26 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B1.500X1.500		Purchased	No			100	f	7.8000	0.7	2.947368			
7075 T6 BAR 1.500 x 1.500													

Location

Loc Qty

Loc Code

MAT08

7.8

111485

7.8

2.9474

886 09/10/23

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	62127
Description: Swing Arm		Part Number:	D3447-9
Inspection Dwg: D3447	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.02	+/-0.030	8.020	✓		Vern	CNC -02
7.075	+/-0.005	7.075	✓		"	"
R0.38	+/-0.030	R0.380	✓		Rod Gage	ref.
Ø0.375	+0.006/-0.001	Ø0.376	✓		Vern	GA-01
0.75	+/-0.030	0.748	✓		"	"
0.375	+/-0.005	0.371	✓		"	"
0.470	+/-0.005	0.471	✓		"	"
1.100	+/-0.010	1.102	✓		Heith gage	31006
0.71	+/-0.030	0.705	✓		Vern	GA-01
0.178	+/-0.010	0.176	✓		"	"
1.825	+/-0.010	1.824	✓		"	"
2.375	+/-0.010	2.375	✓		"	"
R0.25	+/-0.030	R0.250	✓		Rad gage	ref
R0.13	+/-0.030	R0.130	✓		"	"
3.700	+/-0.010	3.700	✓		Vern	GA-01
0.25	+/-0.030	0.249	✓		"	"

Measured by: K.A	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 10/09/26	Date: 10/09/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

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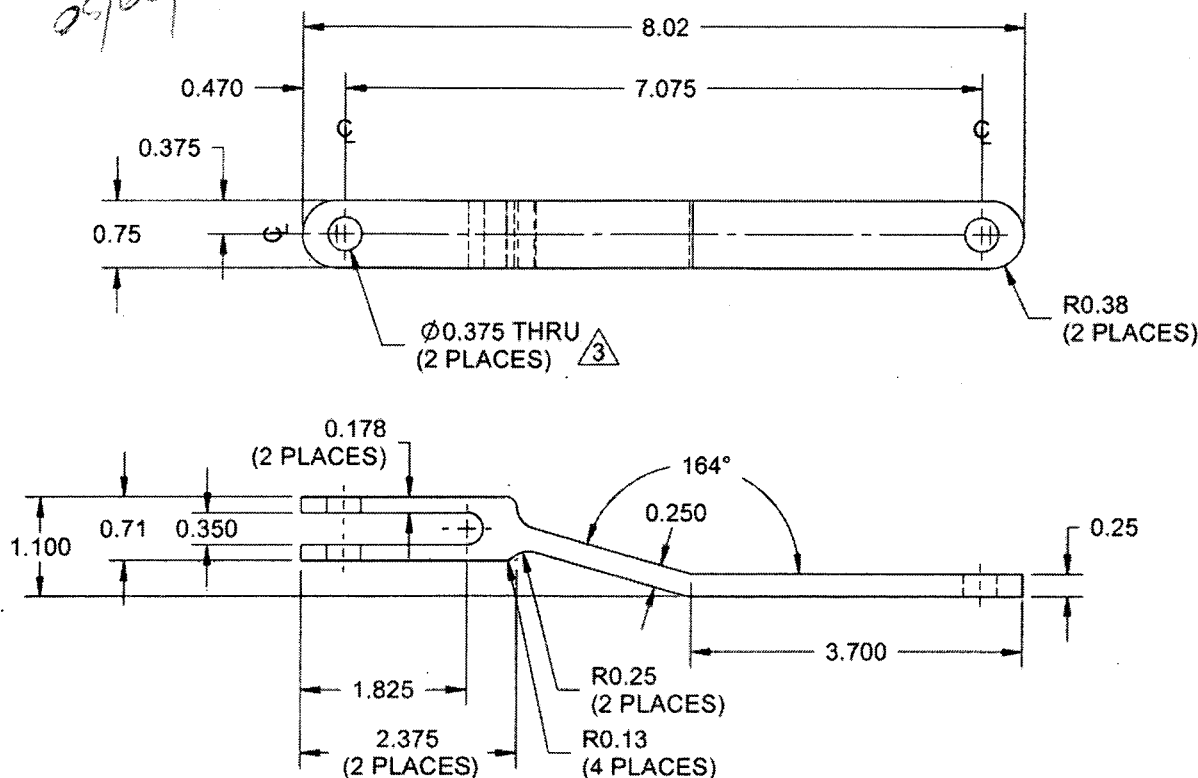
**NOTE:** Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3447</b>	REV. A SHEET 4 OF 4
DATE <b>05.07.19</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:2

RELEASED  
*[Signature]*  
05/08/18

#62127



### **D3447-9 SWING ARM**

**SUPERSEDES PREMIER P/N B67-43001-263**

#### **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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